

Work Order ID 70983 Page 1 Monday, June 20, 2011 2:50:14 PM Item ID: D3396-3 Accept Setup Start **Revision ID:** Stop Item Name: Spacer **Start Date:** 6/20/2011 **Start Qty: 20.00 Cust Item ID:** Required Date: 6/23/2011 Req'd Qty: 20.00 **Customer:** Reference: Start Run Date: //-06-20 Tooling: **Approvals:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Code Qty Stamp Qty Number **Draw Nbr Revision Nbr** D3396 Rev B 100 0.00 Hardinge CNC LATHE SMALL 11/6/22 Hardinge Memo Turn as per Folio FA514 and Dwg D3396□Deburr Hardinge CNC Lathe Small 110 QC2- Inspect parts off machine FAI/FAIB 0/ 1116/22 QC Memo Quality Control

120

QC

QC8- Inspect parts - second check

0.00

20 11.6.22

20 f

Quality Control

Memo

0.00

Dart Aerospace Lt	d
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W/O:			WO	RK ORDER CHANGE	S				****Vdey**
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A :	Date: _	
			Disposition: QA						
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)		· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	Description of NC			ection B Verif			Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Work Order ID 70983

Monday, June 20, 2011 2:50:14 PM



Page 2

Item ID:

D3396-3

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 6/23/2011

Spacer

6/20/2011

Start Qty: 20.00

Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____

Date:

Date: _____

Tooling: SPC (Y/N): Date:

Start Stop

Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Date:

Tool # Plan Code

Accept Qty

Reject Qty

Run

Reject Insp. Number Stamp

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

N 6/23 Af MF 11-06-23

140

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W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		PAR #:	Fault Ca	NCR: Ye	es No	DQ.	A:	Date:			
			Disposition: C								
NCR:	-		WORK OR	DER NON-CONFORMA	NCE (N	CR)					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sig	n & ate	Verific Secti		Approval Chief Eng	Approval QC inspector	
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NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 2:50:20 PM

Work Order ID: 70983

Parent Item:

D3396-3

Parent Item Name: Spacer



Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP A□05.10.03□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		mary Last cation Loca	Route tion Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	_ · ·	Date Issued	Status
MDELRINR0.750		Purchased	No		110	f	97.3400	0.0625	1.315789		,	
									12	6161	122	

Delrin Round Bar 0.75"

Location	Loc Qty	Loc Code	
MAT055	97.34		
115472	7.5		
116183	2.4		
117273 117322 -	38.5		2 () = 7-/
117322 -	0.94		
118066	48		

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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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									, ,
		PAR #:	Fault Categ	NCR: Yes No DQA: Date:					
Resolution: Disposition:				1:	_ QA: N/C Clo	sed:		Date: _	
NCR:		1	WORK ORDE	ER NON-CONFORMA	NCE (NCR)				
DATE	STED	Description of NC	Corrective Action Section B			Verific	ation	Approval	Approval
DAIL	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector	
									
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	70 983
Description: Spacer	Part Number:	D3396-3
Inspection Dwg: D3396 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototyp	е
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.226	+/-0.010	-228			21-1	
Ø0.31 6	+0.005/-0.000	0.316				
Ø0.740	+/-0.010	0.741		,		
0.032 x 45°	+/-0.010	030×45°				
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				-		
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Measured by:		Audited by: 2	<u> </u>	Prototype Approval:	N/A
Date: (/)	6/22	Date: [[6.22	Date:	N/A

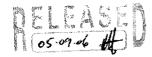
Rev	Date	Change	Revised by	Approved
Α	06.03.09	New Issue	KJ/JLM A	Chl
				7/3/

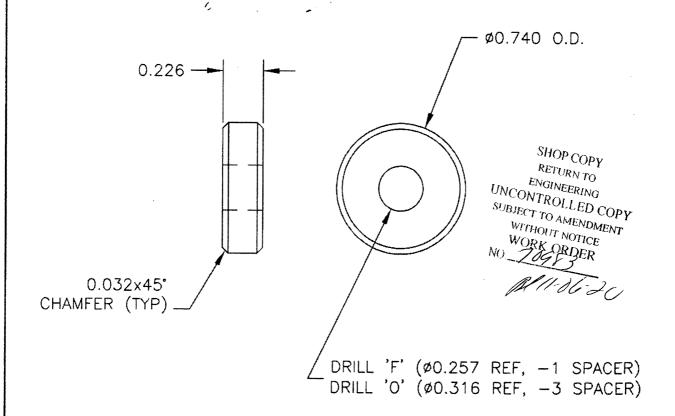
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W/O:			W	ORK ORDER CHANG	GES						
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No		PAR #:	Fault Cat	tegory:	NCR: Yes No DQA: Date:						
	R	esolution:	Disposit	Disposition: QA: N/C Closed:							
NCR:		\	WORK ORI	DER NON-CONFORM	ANCE (NC	R)					
DATE	STEP	Description of NC	Corrective Action Section B			Verific	cation	Approval	Approval		
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NOTE: Date & initial all entries



DESIG	CP	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHEC	(ED AL	APPROVED 4/1	DRAWING NO.	REV. B				
	卅	H	D3396	SHEET 1 OF 1				
DATE		***************************************	TITLE	SCALE				
05.0	4.27		SPACER	2:1				
Α		05.03.10	NEW ISSUE					
В		05.04.27	ADD -3					





D3396-1/-3 SPACER

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:			WO	RK ORDER CHANGES					
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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									,
-									
Part No	•	PAR #:	PAR #: Pault Category:			NCR: Yes No DQA:			
	Re	esolution:				A: N/C Closed:			Date:
NCR:		W	ORK ORDE	ER NON-CONFORMANO	CE (NCR)			
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	Section C	Chief Eng	QC Inspector
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• NOTE: Date & initial all entries